

Work Order ID 63691

November 10, 2010 9:06:03 AM

Page 1

Item ID: D4211-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate, Aft

Start Date: 11/10/10 Start Qty: 10.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D4211 B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg ***Make from D4211-3F***

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-11-11

10

B 10-11-11

Work Order ID 63691

November 10, 2010 9:06:03 AM

Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



8.12/11

0.00

QC

Memo

Quality Control

NO

130

Form as per dwg

0.00



SO 10/11/17

0.00

Brake NC

Memo

Brake NC

10

140

QC5- Inspect part completeness to step on W/O

0.00



8.12/17

0.00

QC

Memo

Quality Control

NO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63691

November 10, 2010 9:06:04 AM

Page 3

Item ID: D4211-043

Accept

Revision ID:

Item Name: Wearplate, Aft

Start Date: 11/10/10 Start Qty: 10.00

Required Date: 11/15/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Hardcoat S.S. Batch: *M116044* 0.00



Large Fab

Memo

0.00

Large Fab

E 10-11-23 *(410)*

160

~~QC9~~ Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

QC10

Memo

0.00

Solules

8/10/11/23

P20

165

QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo

0.00

8/10/11/23

(410)
-243

Dart Aerospace Ltd

W/O: 63691		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/16/73	# 160	perm. change change to a Q10 to have consistency with all other wear plates.	<i>[Signature]</i>	10.11.26			S 10/14/23	

Part No: D4211-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 63691

November 10, 2010 9:06:04 AM

Page 4

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Start Date: 11/10/10 Start Qty: 10.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



11/11/25 88

27 JH 10/11/24

10 0

Powdercoat

Memo

0.00

Powder Coating

Start Time: 9:30AM
Oven Temperature: 320°F
Finish Time: 10:00AM

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/11/24 sl 100

190

Identify as per dwg & Stock Location

0.00



B7

Packaging

Memo

0.00

Packaging

sl 10/11/24 100

W/O:		WORK ORDER CHANGES					
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November 10, 2010 9:06:04 AM

Page 5

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Required Date: 11/15/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/25

ME
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 9:06:02 AM

Page 1

Work Order ID: 63691

Parent Item: D4211-043

Parent Item Name: Wearplate, Aft



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.01 new issue DD verf:EC
10.11.04 as per revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

170.6000

0.0253

0.266316



BO-11-1

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

170.6

111323

0

115688

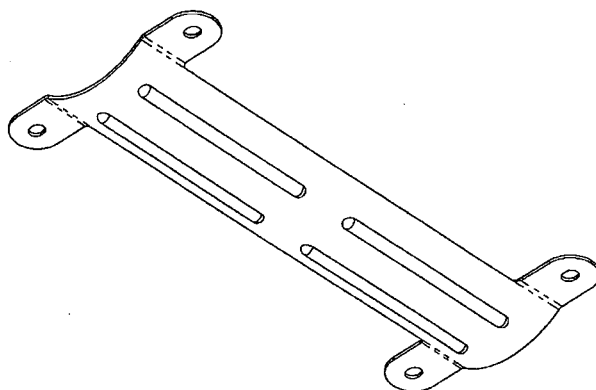
10.6

115953

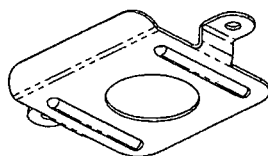
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115688

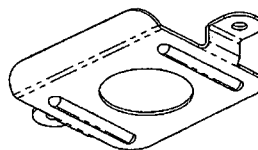
(10)



D4211-041 WEARPLATE



D4211-043 AFT WEARPLATE



D4211-045 AFT WEARPLATE

*WLO
63691*

RELEASED
R 2010-11-03

B	REDESIGNED D4211-043 AND CREATED D4211-045.	MB	10.10.15
A	NEW ISSUE	MB	10.08.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4211	REV. B
TITLE 429 WEARPLATE	SCALE NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

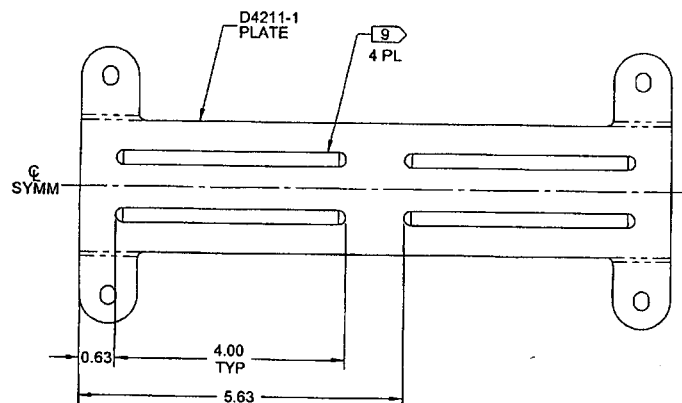
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

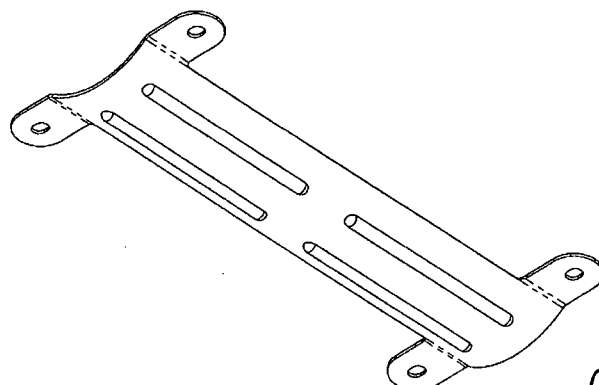
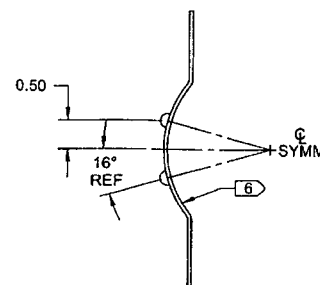
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4211-041	WEARPLATE
1	1	D4211-1	PLATE
2	A/R	2059B	HARDCOAT



D4211-041 WEARPLATE



63691

RELEASED
2010-11-03

D4211-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4211-041" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.64 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD, 0.063 TO 0.125 HIGH

DESIGN	1/1	DART AEROSPACE LTD	
DRAWN	1/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/1	DRAWING NO. D4211	REV. B
MFG. APPR.	1/1		SHEET 2 OF 6
APPROVED	1/1	TITLE 429 WEARPLATE	SCALE
DE APPR.	1/1		NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

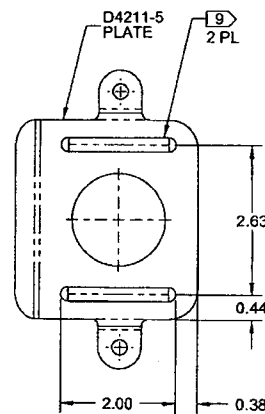
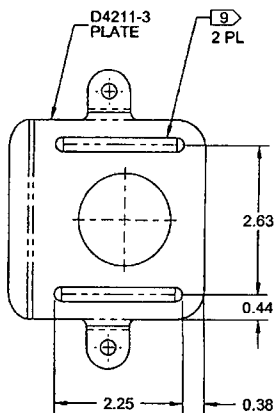
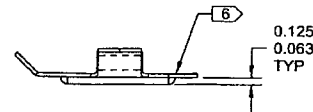
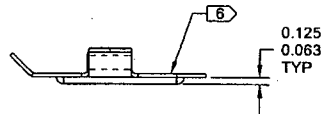
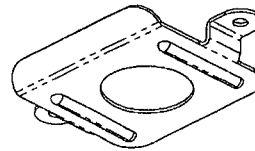
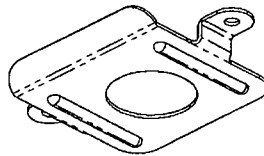
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
	X		D4211-043	AFT WEARPLATE
		X	D4211-045	AFT WEARPLATE
1	1		D4211-3	PLATE
2		1	D4211-5	PLATE
3	A/R	A/R	2059B	HARDCOAT



D4211-043 AFT WEARPLATE

D4211-045 AFT WEARPLATE

D4211-043/-045 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4211-04X" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD, 0.063 TO 0.125 HIGH

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4211	SHEET 3 OF 6
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2010-11-03

63691

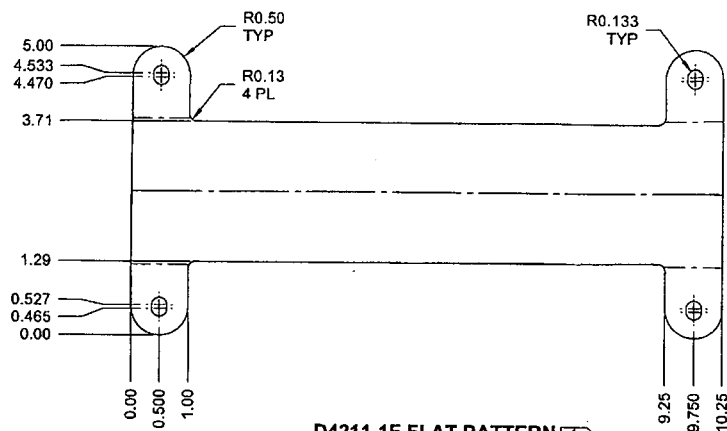
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

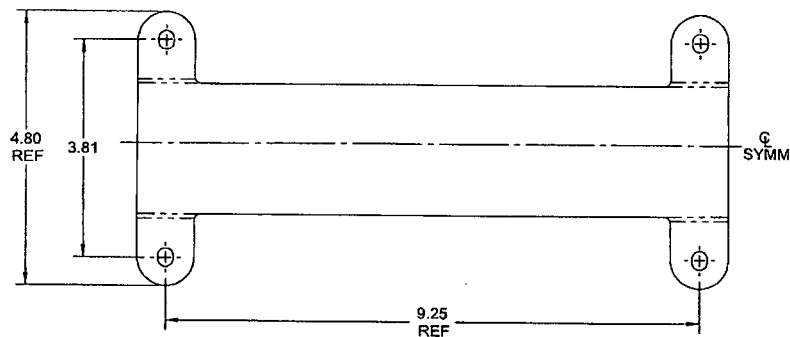
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

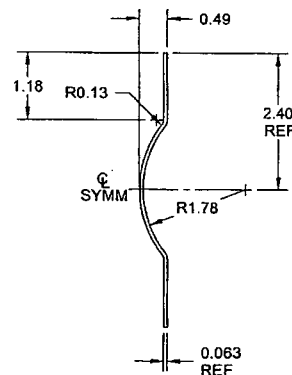
NOTE: Date & initial all entries



D4211-1F FLAT PATTERN



D4211-1 PLATE
(MAKE FROM D4211-1F)



63691

RELEASED
2010-11-03
MD

D4211-1/-1F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.64 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4211	REV. B
MFG. APPR.		SHEET 4 OF 6	
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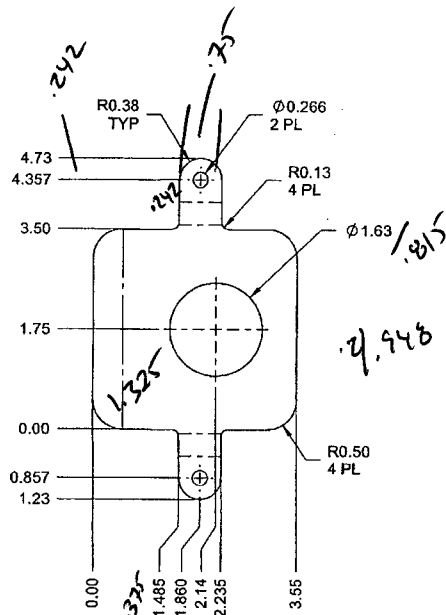
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

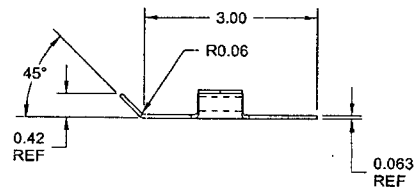
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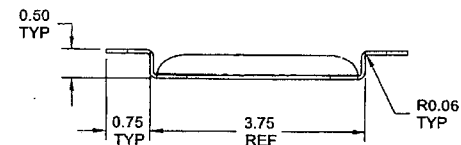
NOTE: Date & initial all entries



D4211-3F FLAT PATTERN



D4211-3 PLATE
(MAKE FROM D4211-3F)



D4211-3/3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
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RELEASE
2010-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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